Date: Friday, 16/01/2009 8:27:03 AM
User: Chantal Lavoie

# Process Sheet

| | | | |
|---|---|---|---|
| **Customer** | : CU-DAR001 Dart Helicopters Services | **Drawing Name** | : AFT DOOR ASSEMBLY |
| **Job Number** | : 44859 | | |
| **Estimate Number** | : 12103 | | |
| **P.O. Number** | : | **Part Number** | : D350588041 |
| **This Issue** | : 16/01/2009 **S.O. No.** : | **Drawing Number** | : D2445, D350-588 P5-6 |
| **Prsht Rev.** | : NC | **Project Number** | : N/A |
| **First Issue** | : / / **Type** : SMALL /MED FAB | **Drawing Revision** | : D,D |
| **Previous Run** | : 41152 | **Material** | : |
| **Written By** | : | **Due Date** | : 27/01/2009 **Qty:** 1 **Um:** Each |
| **Checked & Approved By** | : CL09/01/16 | | |
| **Comment** | : Est P 04.02.04 Reformat KJ/DS | | |

**Additional Product**

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 1.0 | DC | DOCUMENT CONTROL |

HJ for JLD 09/02/02

**Comment:** DOCUMENT CONTROL ECN 09-528 Added 09/03/03
Photocopy bluefile and create labels per PPP D350-588-041 CHG003

| | | |
|---|---|---|
| 2.0 | PG | PURCHASING |

**Comment:** PURCHASING
Issue P/O: 7995 CL09/01/16
Description: D2445 Baggage Door
Supplier: Delastek
Ship to Delastek (1) D0588-041 label
Certification of Conformity and process sheet from Delastek is required.

| | | |
|---|---|---|
| 3.0 | D2445 | Aft Door, 350 |

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Aft Door

| | | |
|---|---|---|
| 4.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |

**Comment:** PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure Certificate of Conformity & Process Sheet are attached 09/01/30

| | | |
|---|---|---|
| 5.0 | QC6 | DIMENSIONAL CHECK |

**Comment:** INSPECT WORK TO CURRENT STEP
Inspect as per Dwg D2445.
Audit process sheet. 09/02/26

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

Date: Friday, 16/01/2009 8:27:03 AM
User: Chantal Lavoie

# Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services **Drawing Name:** AFT DOOR ASSEMBLY

**Job Number:** 44859 **Part Number:** D350588041

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 6.0 | D2143 | Hinge Bracket |

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D2143 Hinge Doubler 33882

09/02/17

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 7.0 | D2144 | Hinge Bracket |

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D2144 Hinge Doubler 41174

09/02/17

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 8.0 | D2463 | Seal |

**Comment:** Qty.: 7.2500 f(s)/Unit Total : 7.2500 f(s)
Neoprene Seal
Pick: Assembly Kit
Qty Part Number Description Batch
1 D2463-0870 ½" Foam Seal 43841

09/02/17

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 9.0 | D2585 | Mounting Channel |

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 D2585 Latch Clamp B45888

09-03-03

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 10.0 | D2586 | Door Latch |

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 D2586 Latch B45554

09-03-3

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

Date: Friday, 16/01/2009 8:27:03 AM
User: Chantal Lavoie

# Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services **Drawing Name:** AFT DOOR ASSEMBLY

**Job Number:** 44859 **Part Number:** D350588041

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 11.0 | D2621 | Latch Plate, 350 Spacepod |

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Latch Plate
Pick: Assembly Kit

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 2 | D2621 | Latch Plate | 38894 |

09/02/17 XL

| | | |
|---|---|---|
| 12.0 | D28571 | Hinge Bracket |

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 1 | D2857-1 | Lower Hinge Bracket | 41166 |

09/02/17 XL

| | | |
|---|---|---|
| 13.0 | D28572 | Hinge Bracket |

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 1 | D2857-2 | Upper Hinge Bracket | 39786 |

09/02/17 XL

| | | |
|---|---|---|
| 14.0 | AN526C832R9 | Screw |

**Comment:** Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick:

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 8 | AN526C832R9 | Screw | M110372 |

09/02/17 XL

| | | |
|---|---|---|
| 15.0 | AN960JD8 | Washer |

**Comment:** Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick:

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 8 | AN960JD8 | Washer | M110382 |

09/02/17 XL

| | | |
|---|---|---|
| 16.0 | AN960JD10 | Washer |

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 2 | AN960JD10 | Washer | M16139 |

09/02/17 XL



Form: rprocess

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

Date: , Friday, 16/01/2009 8:27:03 AM
User: Chantal Lavoie

# Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services **Drawing Name:** AFT DOOR ASSEMBLY

**Job Number:** 44859 **Part Number:** D350588041

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 17.0 | MS21042L08 | Nut |

**Comment:** Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick:
Qty Part Number Description Batch
8 MS21042L08 Nut (or -08) M109174 09/02/17

| | | |
|---|---|---|
| 18.0 | MS21042L3 | Nut |

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 MS21042L3 Nut (or -3) M109798 09/02/17

| | | |
|---|---|---|
| 19.0 | MS27039115 | Screw |

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 MS27039-1-15 Screw M109321 09/02/17

| | | |
|---|---|---|
| 20.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |

**Comment:** SMALL & MEDIUM FAB RESOURCE 1
Assemble all of the above parts as per Dwg D350-588 09-03-3

| | | |
|---|---|---|
| 21.0 | QC5 | INSPECT WORK TO CURRENT STEP |

**Comment:** INSPECT WORK TO CURRENT STEP 09/03/03

| | | |
|---|---|---|
| 22.0 | D2150 | Packer Doubler, Hinge |

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 D2150 Hinge Packer 39780 09/08/04



Form: rprocess

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

Date: , Friday, 16/01/2009 8:27:03 AM
User: Chantal Lavoie

# Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services **Drawing Name:** AFT DOOR ASSEMBLY

**Job Number:** 44859 **Part Number:** D350588041

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 23.0 | D2151 | Packer Doubler, Hinge |

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 D2151 Hinge Doubler B14889 09/03/04

| 24.0 | D2153 | Door Prop |
|---|---|---|

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D2153 Gas Spring Assy 41421 09/03/04

| 25.0 | D2154 | Stud Bracket |
|---|---|---|

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D2154 Stud Bracket 9345814 9/3/11

| 26.0 | D2237 | Striker Plate |
|---|---|---|

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Striker Plate
Pick: Assembly Kit
Qty Part Number Description Batch
2 D2237 Striker Plate 43938 09/03/04

| 27.0 | D2461 | Neoprene "D" Seal |
|---|---|---|

**Comment:** Qty.: 7.2500 f(s)/Unit Total : 7.2500 f(s)
Neoprene "D" Seal
Pick: Kit Picking
Qty Part Number Description Batch
measured 1 D2461-0870 Neoprene `D' Seal 39782 09/03/04

| 28.0 | D2589 | Keys, Key Chain, 350 Hinge |
|---|---|---|

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D2589 Keys, Key Chain B388614 09/03/04


Form: rprocess

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

Date: , Friday, 16/01/2009 8:27:03 AM
User: Chantal Lavoie

# Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services **Drawing Name:** AFT DOOR ASSEMBLY

**Job Number:** 44859 **Part Number:** D350588041

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 29.0 | D28581 | Hinge Bracket |

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D2858-1 Lower Hinge Bracket B39787

09/03/04

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 30.0 | D28582 | Hinge Bracket |

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D2858-2 Upper Hinge Bracket 41439

09/03/04

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 31.0 | AN526C832R8 | Screw |

**Comment:** Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick:
Qty Part Number Description Batch
8 AN526C832R8 Screw M110023

09/03/04

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 32.0 | AN526C1032R7 | Screw |

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 AN526C1032R7 Screw M110715

09/03/04

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 33.0 | AN960JD8 | Washer |

**Comment:** Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
Washer
Pick: Kit Picking
Qty Part Number Description Batch
16 AN960JD8 Washer M110382

09/03/04

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 34.0 | AN960JD10 | Washer |

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
Pick: Kit Picking
Qty Part Number Description Batch
2 AN960JD10 Washer M110139

09/03/04



Form: rprocess

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

Date: Friday, 16/01/2009 8:27:03 AM
User: Chantal Lavoie

# Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services **Drawing Name:** AFT DOOR ASSEMBLY

**Job Number:** 44859 **Part Number:** D350588041

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 35.0 | MS20470AD45 | Rivet, Universal Head |

**Comment:** Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)
Pick:
Qty Part Number Description Batch
18 MS20470AD4-5 Rivet M109031

09/03/04 (X2)

| | | |
|---|---|---|
| 36.0 | MS20426AD34 | RIVET |

**Comment:** Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Pick:
Qty Part Number Description Batch
12 MS20426AD3-4 Rivet M104374

09/03/04 (X3)

| | | |
|---|---|---|
| 37.0 | MS21042L3 | Nut |

**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nut
Pick: Kit Picking
Qty Part Number Description Batch
4 MS21042L3 Nut (or -3) M110399

09/03/04 (X9)

| | | |
|---|---|---|
| 38.0 | MS270390811 | Screw |

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 MS27039-0811 Screw M108335

09/03/04 (X1)

| | | |
|---|---|---|
| 39.0 | MS21042L08 | Nut |

**Comment:** Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
Nut
Pick: Kit Picking
Qty Part Number Description Batch
10 MS21042L08 Nut (or -08) M110002

09/03/04 (X11)



Form: rprocess

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

Date: Friday, 16/01/2009 8:27:03 AM
User: Chantal Lavoie

# Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services **Drawing Name:** AFT DOOR ASSEMBLY

**Job Number:** 44859 **Part Number:** D350588041

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 40.0 | QC4 | INSPECT 100% KITS FOR COMPLETENESS |
| | **Comment:** INSPECT 100% KITS FOR COMPLETENESS | |
| 41.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
| | **Comment:** PACKAGING RESOURCE #1<br>Identify and Stock<br>Location: 41 | |
| 42.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
| | **Comment:** FINAL INSPECTION/W/O RELEASE | |

Job Completion



Form: rprocess

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

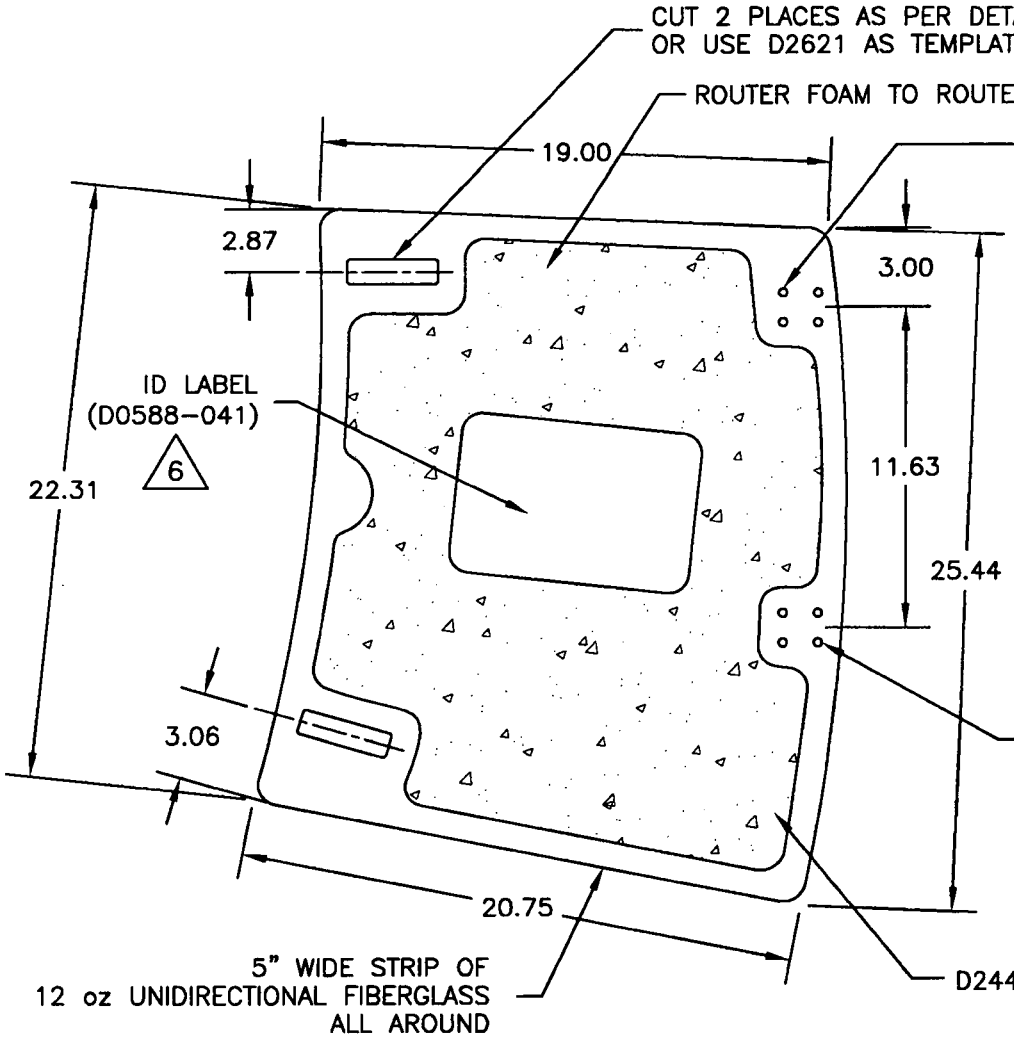
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

| DESIGN | DRAWN BY | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA | |
|---|---|---|---|
| JB | CB | | |
| CHECKED | APPROVED | DRAWING NO. | REV. D |
| | | D2445 | SHEET 1 OF 2 |
| DATE | | TITLE | SCALE |
| 06.06.09 | | AFT BAGGAGE DOOR | 1:7 |

| | | |
|---|---|---|
| A | 97.07.15 | NEW ISSUE |
| B | 02.01.24 | ADD D2621; D2445-101 |
| C | 04.02.09 | REMOVE D2621; UPDATE NOTES |
| D | 06.06.09 | ADD DIMENSIONS TO PERIMETER |

RELEASED
06.11.13



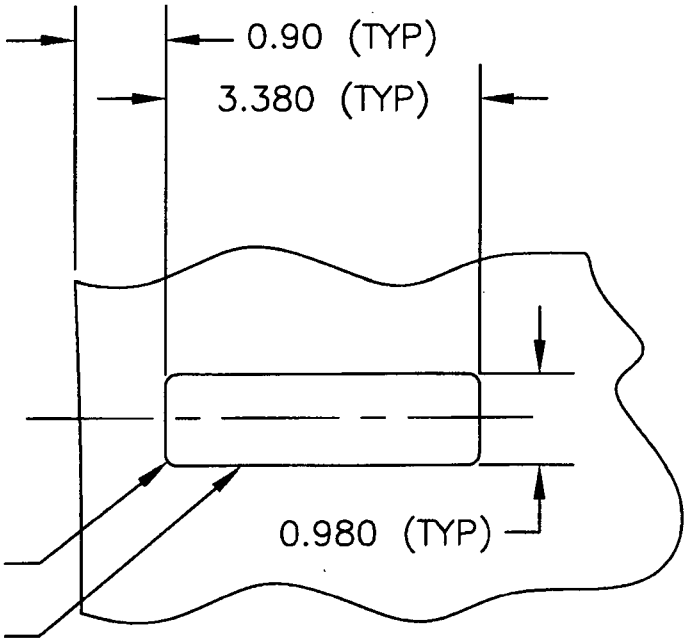

NOTES:
1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
2) RESIN: DERAKANE 411/510A40/470-36
3) FOAM: 3/8" A500 CORE CELL OR DIVINYCELL OR AIREX OR KLEGECELL R-75
4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")
   12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
7) LAMINATE PER DART QSI 006 4.0
8) LAMINATION SCHEDULE PER THIS DRAWING
9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
10) ALL DIMENSIONS ARE IN INCHES
11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44859

**Copyright © 1997 by DART AEROSPACE LTD**
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

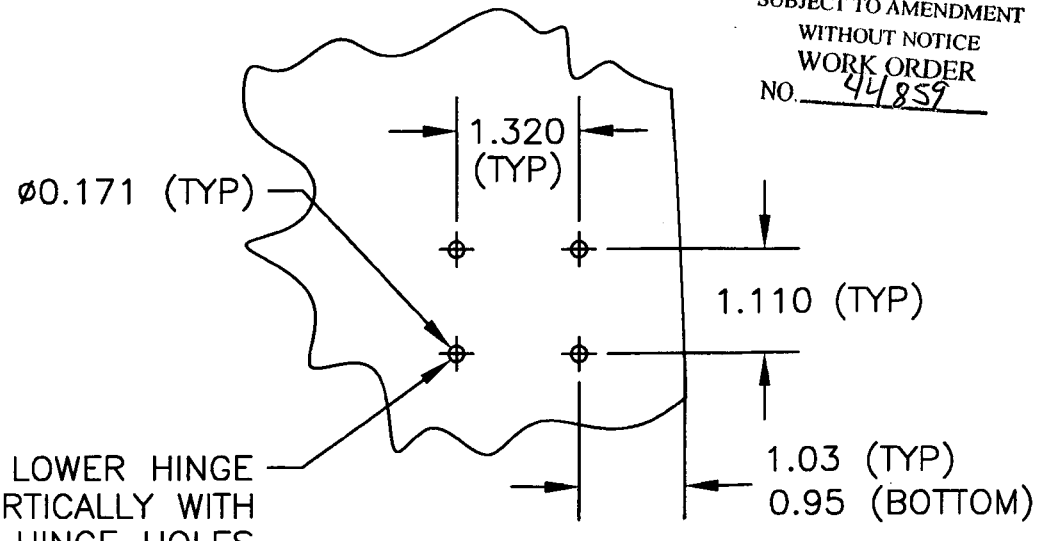
| DESIGN | DRAWN BY | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA | |
|---|---|---|---|
| JB | CB | | |
| CHECKED | APPROVED | DRAWING NO. | REV. D |
| | | D2445 | SHEET 2 OF 2 |
| DATE | | TITLE | SCALE |
| 06.06.09 | | AFT BAGGAGE DOOR | 1:2 |

RELEASED
06.11.13




DETAIL A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41859




DETAIL B

**Copyright © 1997 by DART AEROSPACE LTD**
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44859

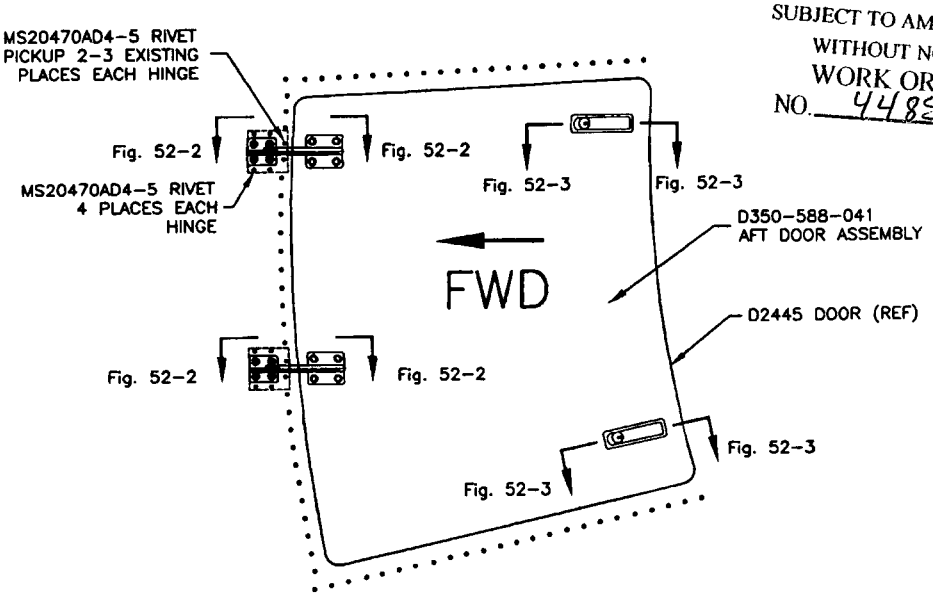



***Figure 52-1: Baggage Door Outside View***

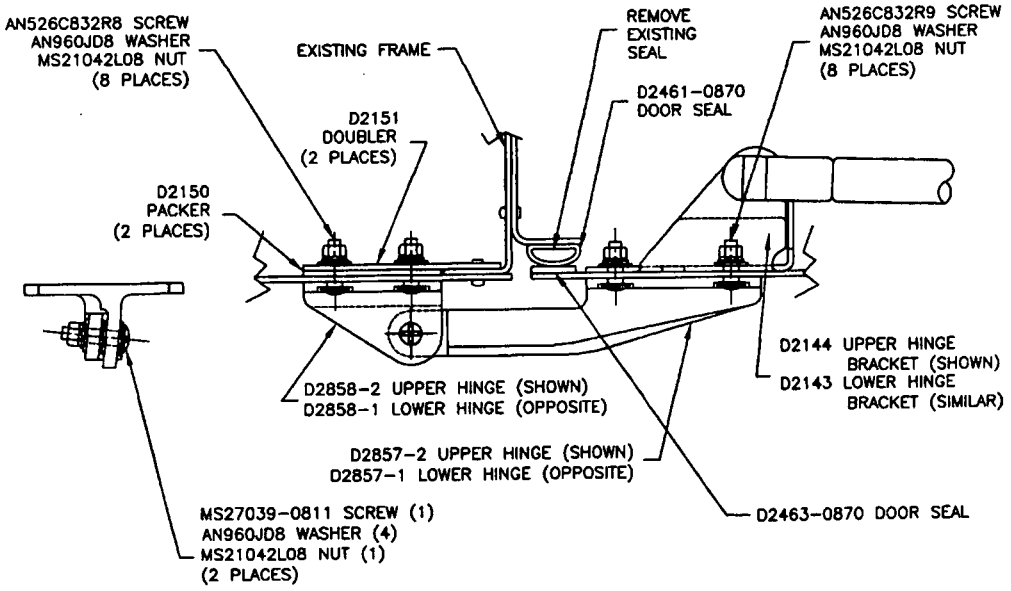
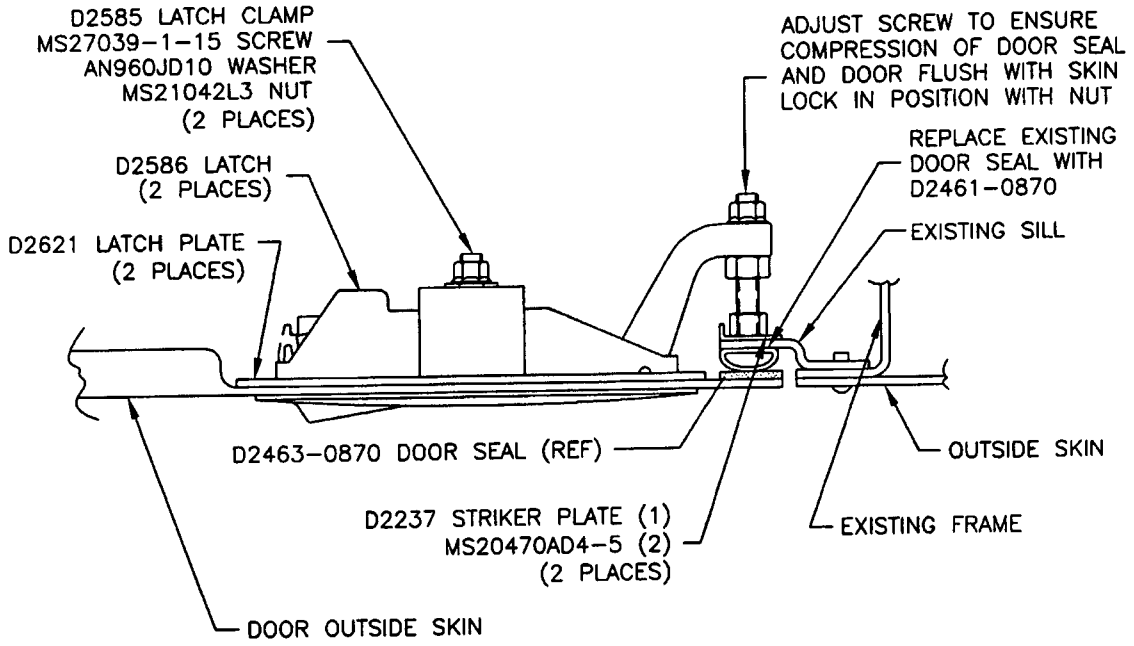



***Figure 52-2: Hinge Detail***

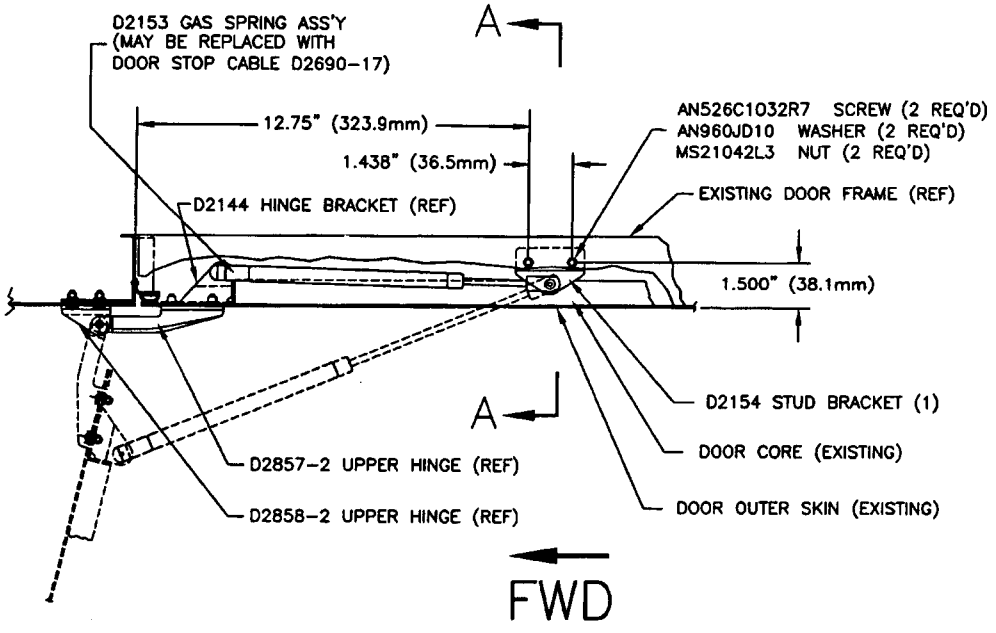
• COPYRIGHT © 2002 BY DART AEROSPACE LTD. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

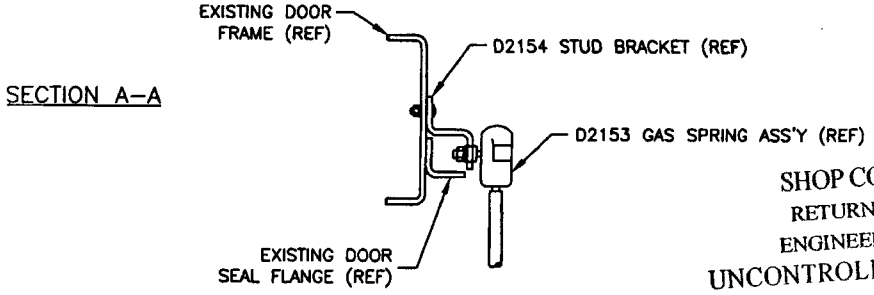



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41859

***Figure 52-3: Latch Section***

• COPYRIGHT © 2002 BY DART AEROSPACE LTD. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.




SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44859

***Figure 52-4: Gas Spring Installation***

• COPYRIGHT © 2002 BY DART AEROSPACE LTD. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

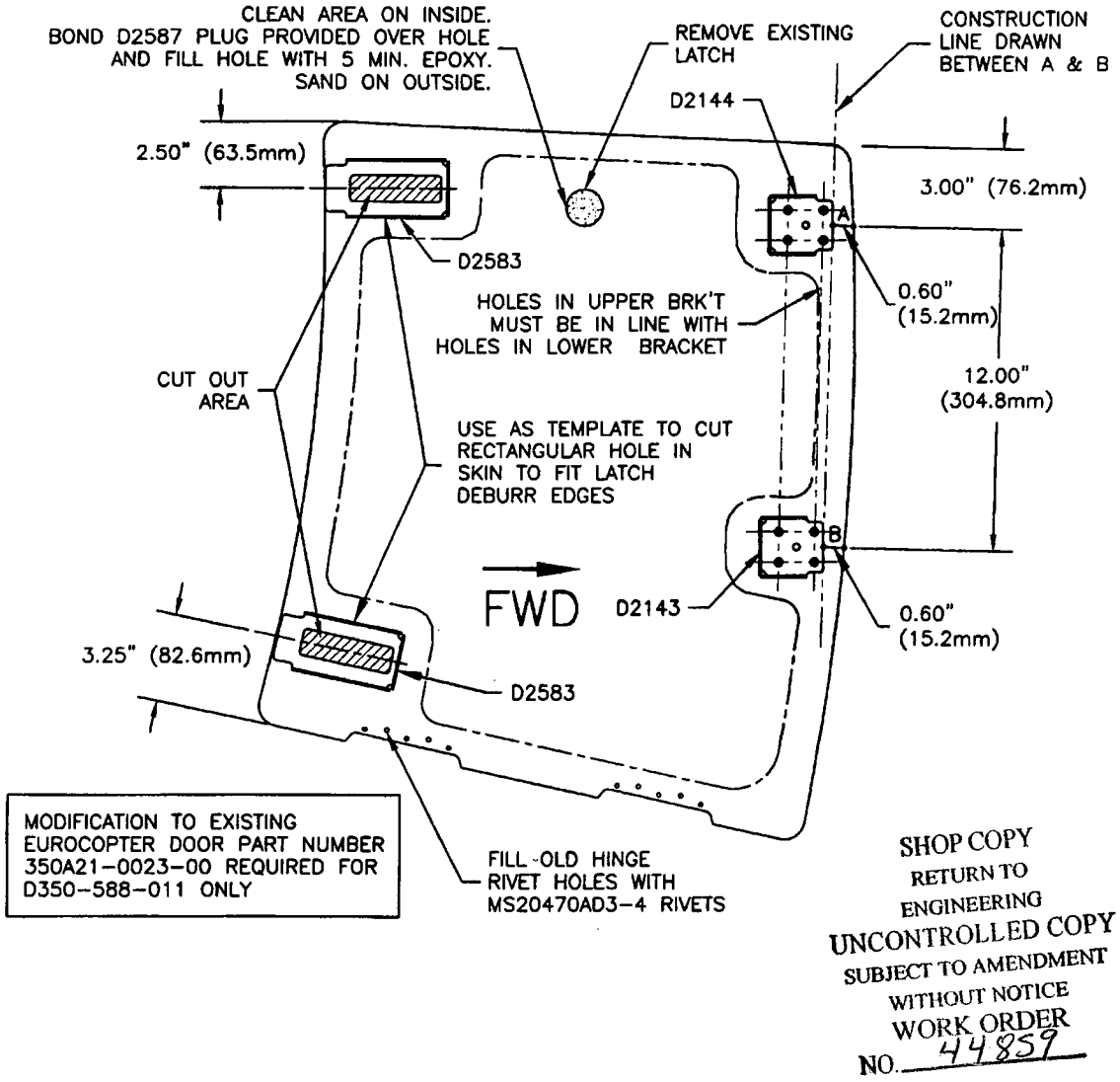
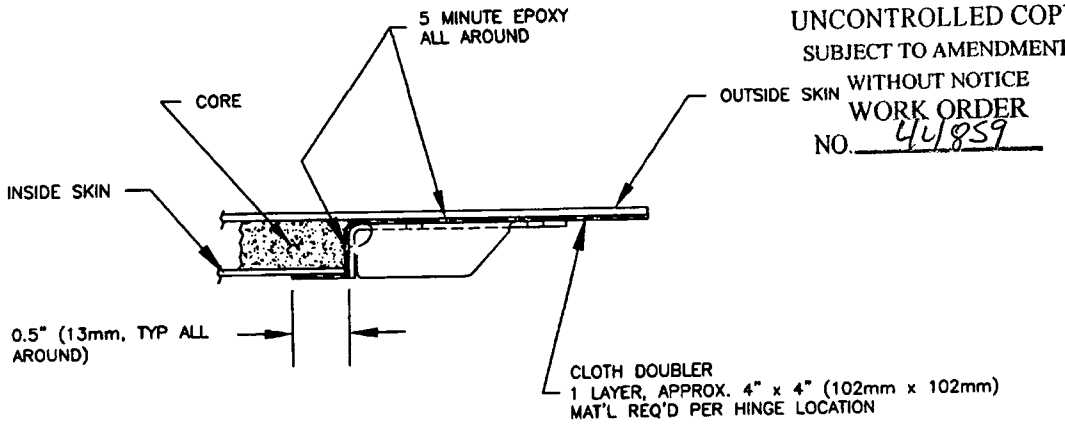



***Figure 52-5: Baggage Door Inside View***

• COPYRIGHT © 2002 BY DART AEROSPACE LTD. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41859




SECTION B–B

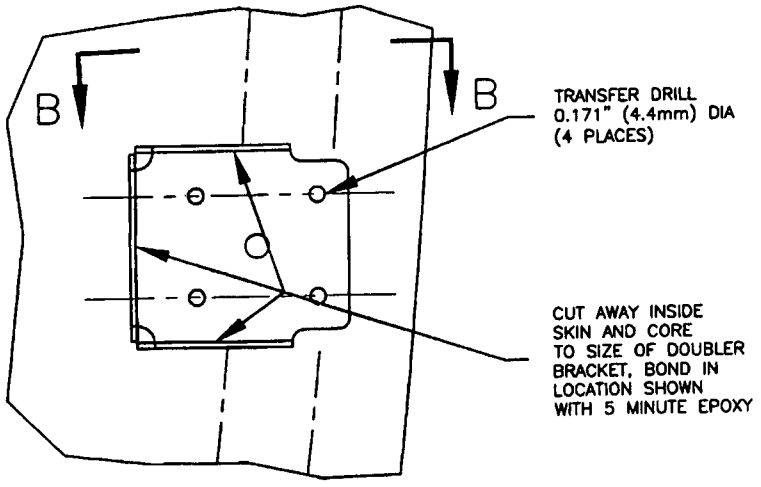



***Figure 52-6: Typical Doubler Bracket Installation***

• COPYRIGHT © 2002 BY DART AEROSPACE LTD. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DELASTEK COMPOSITES

DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

# PACKING SLIP
## CERTIFICATE OF COMPLIANCE

| | |
|---|---|
| **Invoice #** | 13073 |
| **Customer #** | DART |

**Telephone:** (819) 533-5788
**Warehouse:** MAIN

**Bill to:**

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

**Telephone:** 613-632-5200
**Contact:** Linda Lacelle

**Ship to:**

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

| Ship via | F.O.B. | Terms | Salesperson |
|---|---|---|---|
| PURO COLLECT | Origin | Net30 days | Claude Lessard, ext. 233 |

| Ship date | Order Date | Our PO # | Order by | Your PO # | GST/PST # |
|---|---|---|---|---|---|
| 28/01/2009 | 16/01/2009 | 5968 | Chantal Lavoie | PO00007995 | |

| Order Qty | B.O. Qty | Current Ship. | Item # | Item Description | |
|---|---|---|---|---|---|
| 1 | 0 | 1 | DKC134-0013 | D350-588-041 Aft Baggage Door (D2445) B44859<br>Drawing N° : D2445 Rév.: D<br>Job: 43441 | U de M : Each |

09/02/26

*It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.*

Accepted by:

DELASTEK QA-1i

☑ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Quality department AQ-357

Date: Mardi, 2008-10-28 10:07:24
Utilisateur: Marc Dubé

# Feuille de Procédé

| | | | |
|---|---|---|---|
| **Client** | : DART Dart Aerospace Ltd. | **Nom Dessin** | : AFT BAGGAGE DOOR D2445 |
| **Numéro Job** | : 43441 | **Numéro Article** | : DKC134-0013 |
| **Numéro Soumission** | : 2017 | **Numéro Dessin** | : D2445 |
| **Numéro B.A.** | : | **Projet Numéro** | : DKC134 |
| **Cette fois** | : 2008-10-28 **No. B.V.** : | **Révision dessin** | : D |
| **Prsht Rev.** | : NC | **Matériel** | : Fibre 7781 et Résine 411-350 |
| **Prem. fois** | : - - **Type** : | **Date Dûe** | : 2008-11-04 **Qté:** 1 **UdM:** UNITE |
| **Job précédente** | : 43440 | | |

DELASTEK COMPOSITE 15

**Écrit par** : _____

**Vérifié & Approuvé par** : _____

**Commentaires** : N° de pièce Dart Aérospace: D2445
N° Delastek Composites: DKC134-0013
N° de projet Delastek: DK-362

Process Sheet Rév.: 10 Modification du planning afin d'y inclure l
N° I.G 0008 ( Primer )

**Produit additionnel**

Numéro Job:

| # Séq.: | Machine ou Opération: | Description : |
|---|---|---|
| 1.0 | AC0303 | Frekote 44NC |
| **Commentair** | Qty.: 0.020 GALLON(s)/Unit Total : 0.020 GALLON(s)<br>Frekote 44NC | |
| 2.0 | PRÉPARATION 3 | PRÉPARATION DU MATÉRIEL DART |
| **Commentair** | Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs<br>PRÉPARATION DU MATÉRIEL DART<br><br>Faire la préparation du moule N° DT-8036 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.<br><br>Date:____ Heure Début:____ Heure Fin:____ Sceau:____ | |
| 3.0 | AAC0273 | Gel Coat Blanc N° Gel 944W005 |
| **Commentair** | Qty.: 0.200 GALLON(s)/Unit Total : 0.200 GALLON(s)<br>Gel Coat Blanc N° Gel 944W005<br><br>N° de Lot: 1-6828-3 | |
| 4.0 | AAC0275 | Catalyst N° DDM-9 |
| **Commentair** | Qty.: 0.0320 PINTE(s)/Unit Total : 0.0320 PINTE(s)<br>Catalyst N° DDM-9<br><br>N° de Lot: 1-6118-3 | |

| # Séq.: | Machine ou Opération: | Description : |
|---|---|---|
| 5.0 | AC0260 | Acetone |
| Commentair | Qty.: 0.125 KILOGRAMME(s)/Unit Total : 0.125 KILOGRAMME(s)<br>Acetone | |
| 6.0 | PRÉPARATION 3 | PRÉPARATION DU MATÉRIEL DART |

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation du matériel :

Dans une quantité de 0.2 gallon de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% D'acétone.

Date 18-11-08 Sceau: DCLABTEK COMPOSITES 34 Temps Début: 8:40 Temps Fin: 8:50

| | | |
|---|---|---|
| 7.0 | GEL COAT. | APPLICATION DE GEL COAT |

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

APPLICATION DE GEL COAT

À l'aide d'un fusil à peinture appliquer une couche entre 15 et 20 millièmes de Gel Coat sur le moule N° DT8036 et laisser sécher pendant un minimum de 12 heures avant de faire le lay-up, mais ne pas dépasser 24 heures de séchage selon l'instruction de travail N° Tec-70.

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Autocontrôle de fabrication.( Visuel du Gel Coat )

Date 18-11-08 Sceau: DCLABTEK COMPOSITES 34 Temps Début: 8:50 Temps Fin: 9:05

| | | |
|---|---|---|
| 8.0 | AC0409 | Tissu à délaminer Release ply B |
| Commentair | Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)<br>Tissu à délaminer Release ply B | |
| 9.0 | AC0407 | Wrightlon 5200 Bleu P3 |
| Commentair | Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)<br>Wrightlon 5200 Bleu P3 | |
| 10.0 | AC0408 | Feutre de drainage N° Airweave N 10 |
| Commentair | Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)<br>Feutre de drainage N° Airweave N 10 | |

**Date:** Mardi, 2008-10-28 10:07:24
**Utilisateur:** Marc Dubé

# Feuille de Procédé

**Client:** DART , Dart Aerospace Ltd.
**Numéro Job:** 43441

**Nom Design:** AFT BAGGAGE DOOR D2445
**Numéro Article:** DKC134-0013

Numéro Job:

| # Séq.: | Machine ou Opération: | Description : |
|---|---|---|
| 11.0 | AC0752 | Stretchlon 200 poche à vid Vert |

**Commentaire** Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)
Stretchlon 200 poche à vide Vert

| | | |
|---|---|---|
| 12.0 | AAC0326 | 9.7 oz Weave "S" glass #F -778150-125Y Volan Finish |

**Commentaire** Qty.: 2.0 VERGE(s)/Unit Total : 2.0 VERGE(s)
9.7 oz 7781 Weave "S" glass #FG-778150-125Y

N° de Lot: 1-6582-1

| | | |
|---|---|---|
| 13.0 | AAC0443 | Fiberglass 12 oz Unidirecti nal |

**Commentaire** Qty.: 0.33 VERGE CAR(s)/Unit Total : 0.33 VERGE CAR( )
Fiberglass 12 oz Unidirectional

N° de Lot: 1-21729-1

| | | |
|---|---|---|
| 14.0 | AC0098 | Ruban à gommer jaune #: T/AT-200Y |

**Commentaire** Qty.: 1.2500 RL(s)/Unit Total : 1.2500 RL(s)
Ruban à gommer jaune #: T/AT-200Y

| | | |
|---|---|---|
| 15.0 | PRÉPARATION 3 | PRÉPARATION DU MATÉRIEL DART |

**Commentaire** Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
PRÉPARATION DU MATÉRIEL DART

Tailler le matériel, selon les différents paterns de découpe comme suit:

4 plis de tissus de 9.7 oz.
1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Strechlon 200.
3 fois le film perforé P-3
3 fois le feutre de drainage
2 fois le tissu à délaminer ( non nécessaire lors du bagging du cor e ).

Appliquer le ruban jaune tout le tour du strechlon 200 en laissant l e papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. t ous en même temps, en les superposant les uns sur les autres.

Date: 01-10-08 Heure Début: 3:20 Heure Fin: 3:40 Sce au: 34

| | | |
|---|---|---|
| 16.0 | AAC0275 | Catalyst N° DDM-9 |

**Commentaire** Qty.: 0.0120 PINTE(s)/Unit Total : 0.0120 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-6118-3


Form: rprocess

Date: Mardi, 2008-10-28 10:07:24
Utilisateur: Marc Dubé

# Feuille de Procédé

**Client:** DART Dart Aerospace Ltd. **Nom Des in:** AFT BAGGAGE DOOR D2445
**Numéro Job:** 43441 **Numéro Arti le:** DKC134-0013

Numéro Job:

| # Séq.: | Machine ou Opération: | Description : |
|---|---|---|
| 17.0 | AAC0324 | Résine (411B7530) 411-35 promo. 75min. |

**Commentair** Qty.: 0.359 KILOGRAMME(s)/Unit Total : 0.359 KILOGRA MME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-22476-1

18.0 PRÉPARATION 3 — PRÉPARATION DU MATÉ RIEL DART

**Commentair** Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantité requises, mix r tio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 18-11-08 Heure Début: 12:40 Heure Fin: 12:45 Scea u: DELASTEK COMPOSITES 34

19.0 LAMINAGE. — LAMINAGE PIÈCE DART

**Commentair** Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
LAMINAGE PIÈCE DART

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 41 -350 sur le moule N° DT 8036 et ensuite imbiber un plis de tissu 9.7 oz.

Recommencer l'opéaration pour le deuxième pli.

Date: 18-11-08 Heure Début: 12:45 Heure Fin: 1:00 Scea u: DELASTEK COMPOSITES 34 DELASTEK COMPOSITE 7

20.0 POCHE À VIDE 1 — FAIRE LA POCHE À VIDE

**Commentair** Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre ui suit:

1- Tissu à délaminer.
2- Film Perforé P-3.
3- Feutre de drainage
4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 18-11-08 Heure Début: 1:00 Heure Fin: 1:10 Sce au: DELASTEK COMPOSITES 34 DELASTEK COMPOSITE 7

Curing début: 12:45 Curing Fin: 8:30


Form: rprocess

Date: Mardi, 2008-10-28 10:07:24
Utilisateur: Marc Dubé

# Feuille de Procédé

**Client:** DART Dart Aerospace Ltd. **Nom Dessin:** AFT BAGGAGE DOOR D2445
**Numéro Job:** 43441 **Numéro Article:** DKC134-0013

Numéro Job:

| # Séq.: | Machine ou Opération: | Description : |
|---|---|---|
| 21.0 | AAC0275 | Catalyst N° DDM-9 |

**Commentair** Qty.: 0.0042 PINTE(s)/Unit Total : 0.0042 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-6118-3

| | | |
|---|---|---|
| 22.0 | AAC0324 | Résine (411B7530) 411-350 promo. 75min. |

**Commentair** Qty.: 0.120 KILOGRAMME(s)/Unit Total : 0.120 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-2276-1 ✓

| | | |
|---|---|---|
| 23.0 | PRÉPARATION 3 | PRÉPARATION DU MATÉRIEL DART |

**Commentair** Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL DART

Faire la préapration de la résine selon les quantités requise, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core.

Laisser sécher pendant 1 heure.

Date: 18-11-08 Heure Début: 11:10 Heure Fin: 11:20 Sceau: DELASTEK COMPOSITES 34

| | | |
|---|---|---|
| 24.0 | AAC0452 | Polybond B46F |

**Commentair** Qty.: 0.045 KIT(s)/Unit Total : 0.045 KIT(s)
Polybond B46F

N° de Lot: 1-6520-1

| | | |
|---|---|---|
| 25.0 | DKC134-0029 | Foam Core N° D2445-101 ( Pour AFT Baggage Door ) |

**Commentair** Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
Foam Core N° D2445-101 ( Pour AFT Baggage Door ) ✓

| | | |
|---|---|---|
| 26.0 | ASSEMBLAGE 3 | ASSEMBLAGE GÉNÉRALE DART |

**Commentair** Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
ASSEMBLAGE GÉNÉRALE DART

Retirez le bagging.

Appliquer une couche de polybond B64F à l'endos du foam core N° DKC134-0029 et positionner le foam sur le moule selon le dessin et selon les lignes de positionnement prévues à cet effet.

Date: 19-11-08 Heure Début: 9:15 Heure Fin: 9:30 Sceau: DELASTEK COMPOSITES 34 DELASTEK COMPOSITE 7



Form: rprocess

Date: Mardi, 2008-10-28 10:07:25
Utilisateur: Marc Dubé

# Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43441

Nom Dessin: AFT BAGGAGE DOOR D2445
Numéro Article: DKC134-0013

Numéro Job:

| # Séq.: | Machine ou Opération: | Description : |
|---|---|---|
| 27.0 | POCHE À VIDE 1 | FAIRE LA POCHE À VIDE |

Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

1- Film Perforé P-3.
2- Feutre de drainage
3- Sac à vide Stretchlon 200.

Laisser sécher pendant 2 heures minimum.

Date: 19-11-08 Heure Début: 9:30 Heure Fin: 9:40 Sceau: DELASTEK COMPOSITES 34 DELASTEK COMPOSITE 7

Curing Début: 9:15 Curing Fin: 10:45

28.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0136 PINTE(s)/Unit Total : 0.0136 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-6118-3

29.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.360 KILOGRAMME(s)/Unit Total : 0.360 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-22476-1

30.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 21-11-08 Heure Début: 9:10 Heure Fin: 9:15 Sceau: DELASTEK COMPOSITES 34

31.0 LAMINAGE. LAMINAGE PIÈCE DAR

Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
LAMINAGE PIÈCE DART

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes


Form: rprocess

Date: Mardi, 2008-10-28 10:07:25
Utilisateur: Marc Dubé

# Feuille de Procédé

**Client:** DART Dart Aerospace Ltd.
**Numéro Job:** 43441

**Nom Dessin:** AFT BAGGAGE DOOR D2445
**Numéro Article:** DKC134-0013

Numéro Job:

| # Séq.: | Machine ou Opération: | Description : |
|---|---|---|

allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz.

DAte: 21-11-08 Heure Début: 9:15 Heure Fin: 9:45 Sceau: DELASTEK COMPOSITES 34 DELASTEK COMPOSITE 7

32.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE

**Commentair** Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

1- Tissu à délaminer.
2- Film perforé P-3.
3- Feutre de drainage
4- Sac à vide Stretchlon 200.

Laisser sécher pendant 4 heures minimum.

Date: 21-11-08 Heure Début: 9:45 Heure Fin: 9:55 Sceau: DELASTEK COMPOSITES 34 DELASTEK COMPOSITE 7

Curing Début: 9:15 Curing Fin: 8:00

33.0 DÉMOULAGE 1 DÉMOULAGE PIÈCE DART

**Commentair** Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
DÉMOULAGE PIÈCE DART

Démouler la pièce en faisant bien attention de ne pas abimer les coins et les " edges ".

Date: 26-11-08 Heure Début: 2:10 Heure Fin: 2:15 Sceau: DELASTEK COMPOSITES 34

34.0 TRIMAGE 3 TRIMAGE COMPOSITES DART

**Commentair** Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TRIMAGE COMPOSITES DART

?

À l'aide du gabarit N°DT 8619 trimer la pièce en utilisant un routeur muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de penture selon le dessin N° D2445.

Date: 19-01-09 Heure Début: 10:30 Heure Fin: 11:00 Sceau: DELASTEK COMPOSITES 34

Date: Mardi, 2008-10-28 10:07:25
Utilisateur: Marc Dubé

# Feuille de Procédé

**Client:** DART Dart Aerospace Ltd. **Nom Des in:** AFT BAGGAGE DOOR D2445
**Numéro Job:** 43441 **Numéro Arti le:** DKC134-0013

Numéro Job:

| # Séq.: | Machine ou Opération: | Description : |
|---|---|---|
| 35.0 | AAC0062 | Label N° D0588-041 |

**Commentair** Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
Label N° D0588-041

| | | |
|---|---|---|
| 36.0 | AAC0444 | Surface Veil |

**Commentair** Qty.: 0.07 VERGE CAR(s)/Unit Total : 0.07 VERGE CAR( )
Surface Veil

| | | |
|---|---|---|
| 37.0 | AAC0501 | Résine Mia-Poxy |

**Commentair** Qty.: 0.007 GALLON(s)/Unit Total : 0.007 GALLON(s)
Résine Mia-Poxy

| | | |
|---|---|---|
| 38.0 | AAC0502 | Durcisseur 95 Pour Résine Mia-Poxy |

**Commentair** Qty.: 0.007 PINTE(s)/Unit Total : 0.007 PINTE(s)
Durcisseur 95 Pour Résine Mia-Poxy

| | | |
|---|---|---|
| 39.0 | FAB GÉNÉRALE 3 | FABRICATION GÉNÉRAL E DART |

**Commentair** Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
FABRICATION GÉNÉRALE DART

Coller le abel N° D0588-041 selon les séquences suivantes:

1- Surface Veil
2- Label
3- Surface Veil

Laisser scher pendant 4 heures.

Date: 21-1-09 Heure Début: 3:40 Heure Fin: 3:55 Sce au: DELASTEK COMPOSITES 34

| | | |
|---|---|---|
| 40.0 | AC0058 | Polysoft 1.3 kg # 003012 Sikkens |

**Commentair** Qty.: 0.025 UNITE(s)/Unit Total : 0.025 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6782-1

| | | |
|---|---|---|
| 41.0 | AC0059 | Durcisseur Polysoft #004 09 Sikkens |

**Commentair** Qty.: 0.020 UNITE(s)/Unit Total : 0.020 UNITE(s)
Durcisseur Polysoft #004009 Sikkens

| | | |
|---|---|---|
| 42.0 | FINITION 3 | FINITION PIÈCE DART |

**Commentair** Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
FINITION PIÈCE DART

Faire les réparation de finition s'il y a lieu à l'aide du Sikkens.

Date: 19-01-09 Heure Début: 3:30 Heure Fin: 3:45 Sce au: DELASTEK COMPOSITES 34

Date: Mardi, 2008-10-28 10:07:25
Utilisateur: Marc Dubé

# Feuille de Procédé

**Client:** DART Dart Aerospace Ltd.
**Numéro Job:** 43441

**Nom Dessin:** AFT BAGGAGE DOOR D2445
**Numéro Article:** DKC134-0013

Numéro Job:

| # Séq.: | Machine ou Opération: | Description : |
|---|---|---|
| 43.0 | AAC0683 | Dupont Primer N° 7704S |

**Commentair** Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-21723-1

| | | |
|---|---|---|
| 44.0 | AAC0685 | Dupont Activator - Reducer Chromabase N° 7775S |

**Commentair** Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)
Dupont Activator - Reducer Chromabase N° 7775S

| | | |
|---|---|---|
| 45.0 | PRIMER | APPLICATION DE PRIMER |

**Commentair** Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
APPLICATION DE PRIMER

Appliquer le primer selon I.G. 0008

Quantité: 1 Date: 21-01-09 Sceau: DELASTEK COMPOSITES

Quantité: 1 Date: 22-01-09 Sceau: DELASTEK COMPOSITES

Quantité: _____ Date: _____ Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

| | | |
|---|---|---|
| 46.0 | INSPECTION 3 | INSPECTION PIÈCE DART |

**Commentair** Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
INSPECTION PIÈCE DART

Faire l'inspection selon le dessin N° D2445.

Date: 28/01/09 Heure Début: 8:30 Heure Fin: 8:40 Sceau: DELASTEK QA-11

| | | |
|---|---|---|
| 47.0 | EMBALLAGE | EMBALLAGE ET ENTREPOSAGE |

**Commentair** Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
EMBALLAGE ET ENTREPOSAGE

Faire l'emballage des pièces.

Quantité: 1 Date: 28-1-09 Sceau: DELASTEK 11

Quantité: _____ Date: _____ Sceau: _____